

PAINT SPECIFICATIONS

PRIME PAINT

All Republic's doors and frames are thoroughly cleaned and phosphatized prior to painting. The prime paint used on Republic's doors is a Modified Alkyd-Acrylic Enamel and the paint used on Republic's frames is a Water Based Alkyd-Melamine Primer. Both materials are forced cured after painting to maximize adhesion and strength. Republic's primers are capable of meeting the requirements as specified by ANSI A250.10, which include but are not limited to the following:

ASTM B117	Method of Salt Spray (Fog) Testing (120 continuous hour exposure)
ASTM D4585	Standard Practice for Testing Water Resistance of Coating Using Controlled Condensation (240 continuous hour exposure)
ASTM D2794	Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact) (20 in./lbs. direct impact)
ASTM D3359	Standard Test Method for Measuring Adhesion by Tape Test

The gloss for Republic's primer is less than 10% reflectance measured using a 60° gloss meter.

FINISH PAINT

All Republic's doors and frames requiring finish paint are primed as specified above then coated with a Modified Alkyd Urea Enamel and forced cured. Republic's finish painted products are capable of meeting the requirements as specified by ANSI A250.3, which include but are not limited to the following:

ASTM B117	Method of Salt Spray (Fog) Testing (120 continuous hour exposure)
ASTM D4585	Standard Practice for Testing Water Resistance of Coating Using Controlled Condensation (480 continuous hour exposure)
ASTM D2794	Standard Test Method for Resistance of Organic Coatings to the Effects of Rapid Deformation (Impact) (20 in./lbs. direct impact)
ASTM D3359	Standard Test Method for Measuring Adhesion by Tape Test

The gloss for Republic's finish paint is 15% ± 5% reflectance measured using a 60° gloss meter.

Republic's prime paint and finish paint comply with Public Law 91-695, Lead Based Paint Poisoning Prevention Act.

Revised 8/09



Primer



No. FP-3 Midnite Bronze



No. FP-4 Cream Buff



No. FP-5 Black



No. FP-7 Stone White



No. FP-9 White

OTHER COLORS ARE AVAILABLE ON REQUEST.

FIELD PAINTING

The primer used on Republic doors and frames will accept most commercially available top coat material if that top coat is applied according to the manufacturer's instruction for application.

For superior paint adhesion we recommend lightly sanding the door or frame to remove any foreign matter that may have gotten onto the surfaces during construction. A door or frame should be wiped clean with a clean rag or tack cloth prior to painting. Do not use lacquer thinner or any solvent that may react on the primer. Never use gasoline, kerosene or an acid. If there is any question about using a particular finish coat over the primed doors or frames, a small section of primed metal should be tested before painting the entire area.

For optimum long-term performance, an air-dry vinyl wash primer can be applied to sanded areas to give maximum adhesion. Allow the wash primer to dry thoroughly before applying touch-up paint or top coat.

The following families of paints have been used to top coat the prime paint with resulting successful intercoat adhesion. This list comprises a wide variety of finish coat paints but is by no means conclusive.

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| 1. Air dry alkyd (long, medium or short oil) | 4. Alkyd/Urea Formaldehyde (air dry) |
| 2. Air dry acrylic lacquer | 5. Water-based acrylic emulsion |
| 3. Chlorinated rubber enamel | 6. Epoxy/urea formaldehyde (two-component) |

For other paint qualities not listed here (such as two-component urethanes, latex, etc.), check the manufacturer's instructions before applying. Some commercial paints are not recommended for use as topcoats over alkyd primers. Contact Republic Doors and Frames with any questions regarding a proposed topcoat (not shown above) before painting primed doors.

PHOSPHATIZING

A superior prime paint or finish paint process must initiate with a superior pretreat of the surface to be coated.

The Republic door and frame has such a superior pretreat system. During this phosphatizing process (five stage for doors; two stage for frames) the door or frame is thoroughly cleaned, the phosphatizing agent is applied and is fixed to the surface.

Phosphatizing is a method of chemically producing a phosphate coating on steel that is composed of millions of microscopic crystals integrated with the metal.

Insoluble in water, this coating effectively retards corrosion resulting from moisture that may penetrate the paint film. It provides a foothold for the paint and prevents flaking or peeling. The phosphatized coating is softer than the base metal and is adherently etched into the metal surface.

NOTE: We reserve the right, without notice, to make changes in specifications, construction, design and details at any time, in such manner as we may consider necessary or advisable. Corrections to reflect any such changes shall be included in subsequent printing of this publication.